

Work Order ID 50015

July 2, 2009 3:48:44 PM

Page 1

Item ID: D2229

Revision ID: B

Item Name: Doubler

Start Date: 07/06/2009 Start Qty: 10.00

Required Date: 07/10/2009 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2229

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2229 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

ml 09 07 07 (10)
Deburr m-l 09/07/08 (10X)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8 09/02/07 (10)

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Item ID: D2229

Accept



Setup Start



Revision ID: B

Item Name: Doubler

Stop



Start Date: 07/06/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 07/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

m-h

09/07/08

(10X)

Small Fab

Deburr. No sharp edges

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

gh

09-07-09

(X10)

Hand Finishing

150



QC

QC3- Inspect Part Finish

Memo

0.00

0.00

04-07-9

(10)

BR

Quality Control

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Item ID: D2229

Accept



Setup Start



Revision ID: B

Stop



Item Name: Doubler

Start Date: 07/06/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 07/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 2

0.00



Packaging

Memo

0.00

Packaging

9/2/9

54

10x

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/09

mf 09-07-09

Picklist Print

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Work Order ID: 50015

Parent Item: D2229RevB

Parent Item Name: Doubler

Comments:

Start Date: 07/06/2009

Required Date: 07/10/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	168.8200	0.5484			



2024-T3 .063 sheet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

168.82

102942

1.5

105916

3.69

106223

1.47

109463

24.2

110980

15.45

111787

120.51

19059

2

m.mf

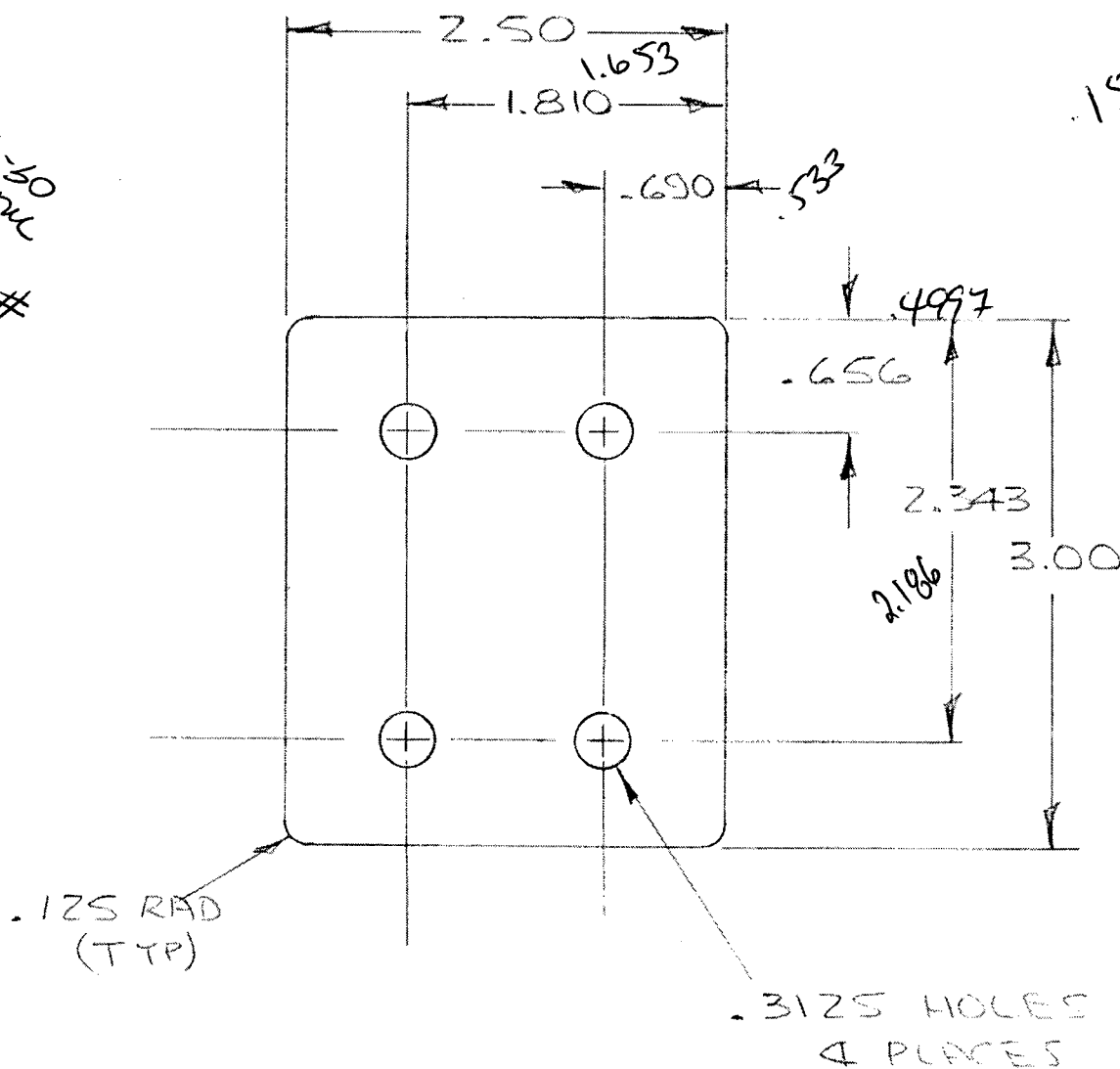
DART



DRAWN BRADLEY 94.3.28		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.3.28	DRAWING NO. D2229	REV B	SHEET 1 OF 1
		TITLE DOUBLER	

A	NEW ISSUE	94/3/88	✓
B	ALODINE W/ ANODIZE	97/1/00	✓

EG-LO-60
S1086 #



MATERIAL: 2074-T3 ALUMINIUM
.063 THICK

FINISH: ALODINE PER QSI 005-4.1